

ASAP

Dart Aerospace Ltd.

Date: Monday, 10/22/2007 3:41:46 PM  
 User: Kim Johnston

## Process Sheet

|  |                              |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : FITTING       |
| Job Number : 35284                             |                              |
| Estimate Number : 10869                        |                              |
| P.O. Number :                                  | Part Number : D32161         |
| This Issue : 10/22/2007 S.O. No. :             | Drawing Number : D3216 REV A |
| Prsht Rev. : NC                                | Project Number : N/A         |
| First Issue : / / Type : SMALL /MED FAB        | Drawing Revision : A         |
| Previous Run : 30615                           | Material :                   |
| Written By :                                   | Due Date : 11/5/2007         |
| Checked & Approved By : <u>HA 07.10.23</u>     | Qty: <u>70</u> Um: Each      |
| Comment : Est: A 03.10.28 New Issue KJ/RF      |                              |
| Est Rev:B Now on Waterjet 06-07-03 JLM         |                              |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S11GA | 304/316 .125 Sheet |
|-----|-----------|--------------------|



2.2348



Comment: Qty.: 0.0302 sf(s)/Unit Total: 1.8144 sf(s)

304/316 .125 Sheet

(M304S0125)

Batch: M104 934

HB 07-10-24

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3216

Dwg Rev: AProg Rev: A

HB 07-10-24

(74)

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



HB 07-10-24

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

Er 07/10/24

Covers (X74)

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

2. Tumble until parts have a polished finish.

SAD

07-10-29

(74)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:47 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 35284

Part Number: D32161

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*counted*

Comment: INSPECT WORK TO CURRENT STEP

*07/10/30 (x74)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST77*

*(x74)*

*07/10/31 KS*

*[Signature]*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*07.10.31 [Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07-10-31*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

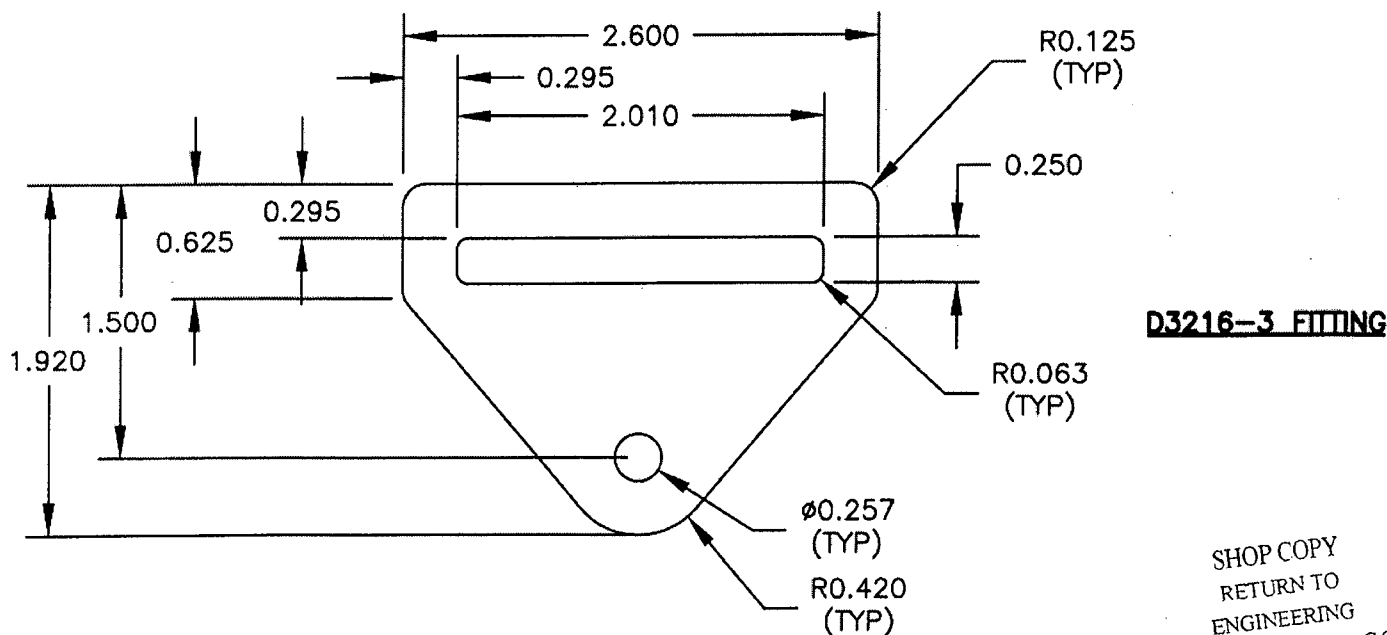
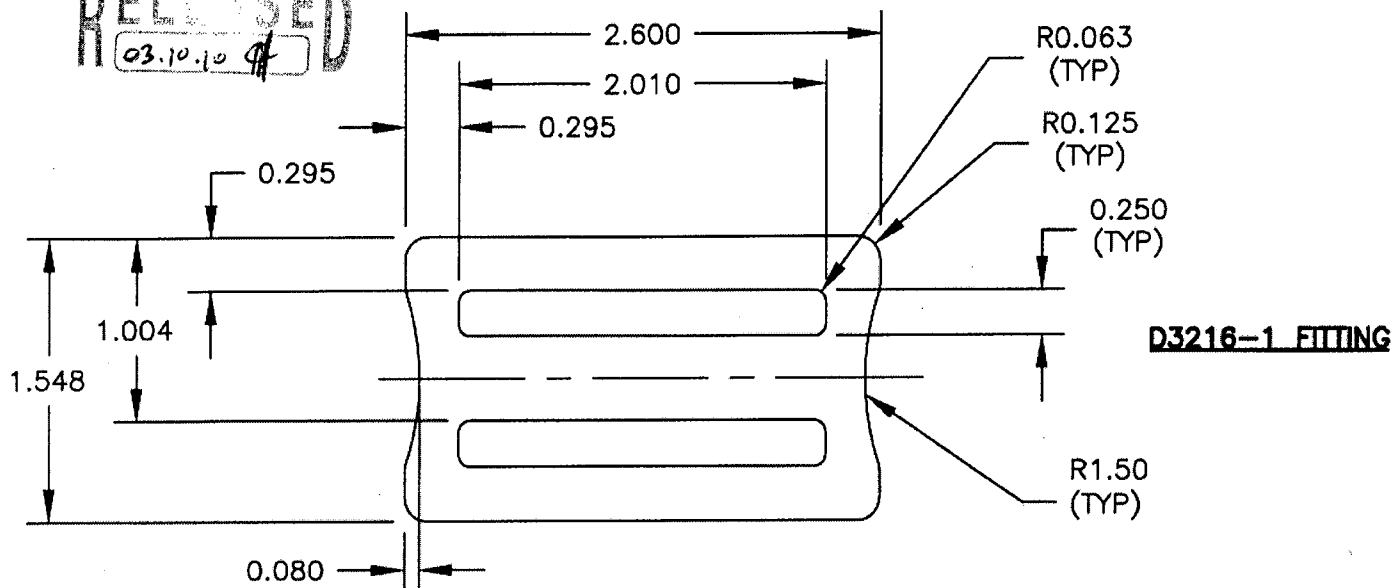
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                               |                                |   |                        |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN<br><i>CP</i>           | DRAWN BY<br><i>CP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3216                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>03.09.26              |                                | TITLE<br>FITTING                                  | SCALE<br>1:1           |
| A                             | 03.09.26                       | NEW ISSUE   |                        |

RELEASED  
03.10.10 *[Signature]*



**D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S11GA)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **35284**

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